

Work Order ID 98235

March-11-13 11:00:30 AM

98235

Page 1

Item ID: D4634-145

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft. Center Ceiling Replacement Panel Assembly

Start Date: 3/11/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/25/13 Req'd Qty: 1.00

1

Customer: -

Reference:

Approvals: Process Plan: MLJ

Date: 13-03-11 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4634

Rev B

[Signature]

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

[Signature]
13/03/25

110

0.00

110

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D4634-145

1- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.

Batch # M 124600

Expiry Date 13/10/16

2- Apply labels as per Dwg. and seal with 3M 3950 edge sealer

[Signature]
13/03/25

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

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Page 2

Item ID: D4634-145

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N900040100

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Revision ID:

Stop ***NS2***

Item Name: Aft. Center Ceiling Replacement Panel Assembly

Start Date: 3/11/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/25/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC6- Inspect dimensions to drawing

0.00
DAS 16
0.00 13/04/11

120

QC Memo

Quality Control

QC

130 Identify as per dwg & Stock Location: _____ 0.00

130

MED FAB, B 92945

Packaging Memo 0.00

Packaging

13/04/11

140 QC21- Final Inspection - Work Order Release 0.00

140

QC Memo 0.00

Quality Control

13/4/12

13-04-11

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

March-11-13 11:00:34 AM

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Work Order ID: 98235

98235

Parent Item: D4634-145

D4634-145

Parent Item Name: Aft. Center Ceiling Replacement Panel Assembly

Start Date: 3/11/13

Required Date: 3/25/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A New Issue 13/02/05 DL VERIFIED BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4664-5		Manufactured	No			100	Each	70.0000	6	6			

~~*D4664-5*~~

Spacer

~~B99997~~

**

N/A

Location	Loc Qty	Loc Code
ST117	40	
93071	40	
ST119	30	
95931	30	

D4647-1

Manufactured No

100

Each

4.0000

1

1

D4647-1✓

Doubler

**

Location	Loc Qty	Loc Code
ST116	4	
92969	4	

D4647-3

Manufactured No

100

Each

15.0000

2

2

D4647-3✓

Angle

**

Location	Loc Qty	Loc Code
ST117	15	
92970	15	

D46
07
89
13/04/09

D46
07
89
13/04/09

2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

March-11-13 11:00:34 AM

Page 2

Work Order ID: 98235

98235

Parent Item: D4634-145

D4634-145

Parent Item Name: Aft. Center Ceiling Replacement Panel Assembly

Start Date: 3/11/13

Required Date: 3/25/13

Start Qty: 1.00

Required Qty: 1.00

D4664-5 Manufactured No

Each 70.0000 6

D4664-5

Spacer

**

Location

Loc Qty

Loc Code

ST117

40

~~93071~~

40

ST119

30

~~93931~~

30

x6

D46
07
89
13/04/10

D4694-045 Manufactured No

100 Each

1.0000

1

D4694-045

Aft Channel Assembly

**

1

D46
07
89
13/04/09

Location

Loc Qty

Loc Code

ST158

1

95819

1

100

Each

2.0000

1

1

D46
07
89
13/04/09

D4694-047 Manufactured No

D4694-047 ✓

Aft Channel Assembly

**

Location

Loc Qty

Loc Code

st1258

2

93079

2

100

Each

10.0000

1

1

D46
07
89
13/04/09

D4732-17 Manufactured No

D4732-17 ✓

Label

**

Location

Loc Qty

Loc Code

ST120

10

93378

10

March-11-13 11:00:34 AM

Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabelled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
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		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
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		<input type="checkbox"/> Other

Picklist Print

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Page 3

Work Order ID: 98235

98235

Parent Item: D4634-145

D4634-145

Parent Item Name: Aft. Center Ceiling Replacement Panel Assembly

Start Date: 3/11/13

Required Date: 3/25/13

Start Qty: 1.00

Required Qty: 1.00

D4732-27

Manufactured No

100 Each

10.0000

1

D4732-27 ✓

Label

**

Location

Loc Qty

Loc Code

ST120

10

93195

10

D4732-23

Manufactured No

100 Each

10.0000

1

D4732-23 ✓

Label

**

Location

Loc Qty

Loc Code

ST120

10

93280

10

MPNY-750S-9-C

Purchased

No

100 Each

100.0000

8

MPNY-750S-9-C ✓

Mounting Pad

**

Location

Loc Qty

Loc Code

ST390

100

124058

100

MS20426AD3-3

Purchased

No

100 Each

7,041.000

4

MS20426AD3-3

Rivet

**

Location

Loc Qty

Loc Code

GA

65

122814

65

ST316

699

119109

282

19099

417

ST333

6277

121011

69

123352

6208

DAS
07
2-89
13/04/09

DAS
07
2-89
13/04/09

DAS
07
2-89
13/04/09

DAS
07
2-89
13/04/09

March-11-13 11:00:34 AM

Shop Packet Print

Page 3

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
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<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

March-11-13 11:00:34 AM

Page 4

Work Order ID: 98235

98235

Parent Item: D4634-145

D4634-145

Parent Item Name: Aft. Center Ceiling Replacement Panel Assembly

Start Date: 3/11/13

Required Date: 3/25/13

Start Qty: 1.00

Required Qty: 1.00

MS21059L3

Purchased

No

100

Each

299.0000

2

MS21059L3

Nut Plate

**

2

DAS
07
89

13/04/09

Location

Loc Qty

Loc Code

ST316

99

124291

99

ST506

200

124308

200

D4634-5.

B 92947.

1

DAS
07
89

13/04/09

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

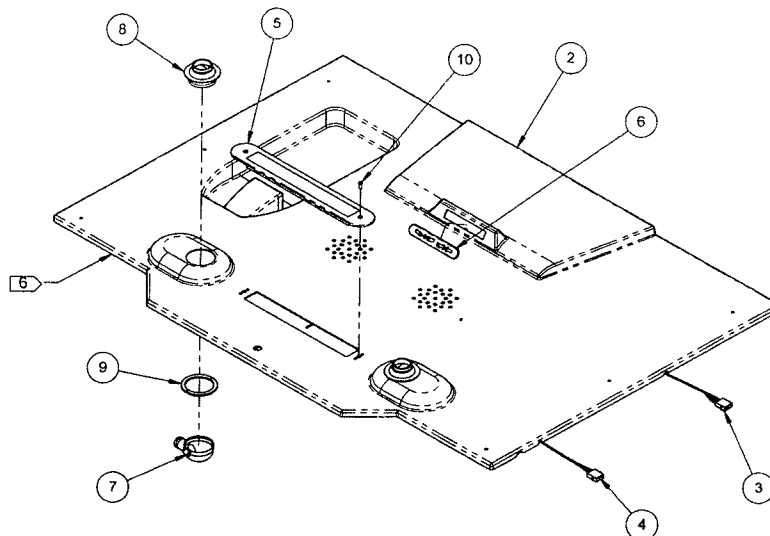
QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other



D4634-041 FWD, CENTER CEILING PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 7.5 lbs
- 8) INSTALL D4728-047/-051 WIRE HARNESS PER QSI 048

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4634-041	FWD, CENTER CEILING PANEL ASSY
2	1	D4634-141	FWD, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4728-047	ADVISORY LIGHT (FWD) HARNESS ASSEMBLY
4	1	D4728-051	CABIN LIGHT #1 HARNESS ASSEMBLY
5	1	D4638-1	LED LIGHT
6	1	D4645-1	NO SMOKING & FASTEN BELT LIGHT
7	2	D4646-1	PLENUM CAP ASSEMBLY
8	2	D4652-1	AIR VALVE
9	2	D4652-3	MOUNTING NUT
10	2	MS24694-S5	SCREW
11	8	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

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FOR INFORMATION

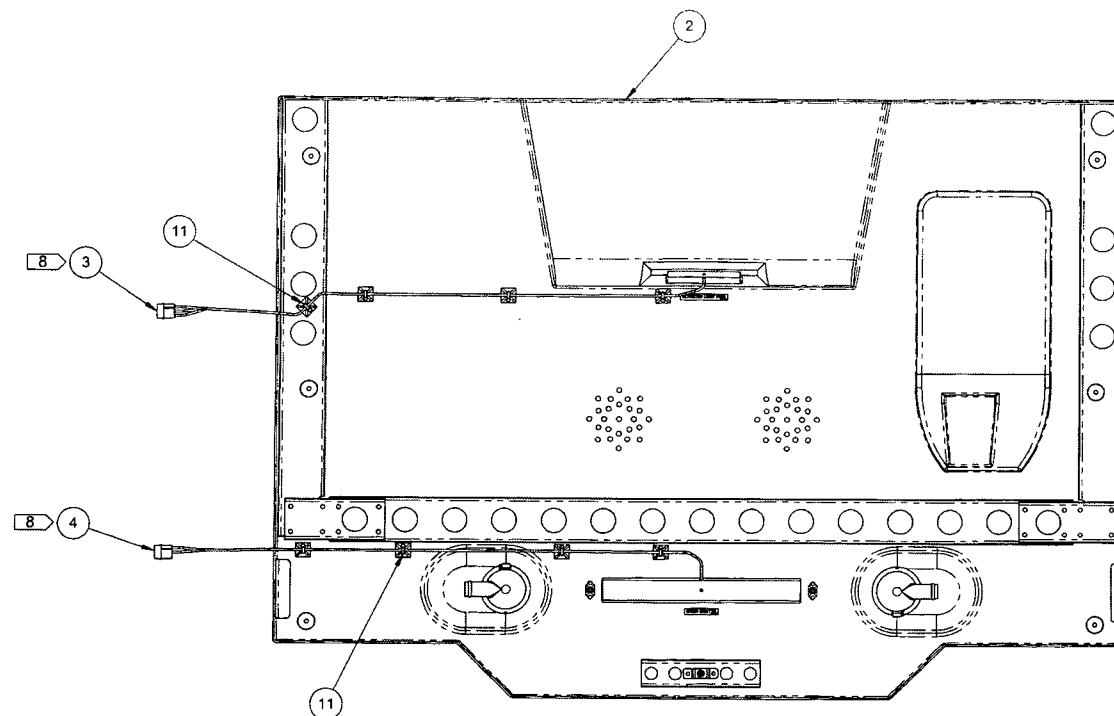
98235 MLC

13-03-11

RELEASED
R 2013-01-30

B	ADDED D4634-141/143/145 (ZN B4-7, B4-8, B4-9); REVISE D4634-041/-042/-043/-044 PART LIST & GENERAL NOTES; ADD DETAILS R.S.T SHT 10, 12, 14, 16, 17		RF	12.11.30
A	NEW ISSUE		RF	12.07.25
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	RF	DRAWING NO.	REV. B	
MFG. APPR.	RF	D4634	SHEET 1 OF 17	
APPROVED	RF	TITLE	SCALE	
DE APPR.	RF	CENTER CEILING PANELS		NTS
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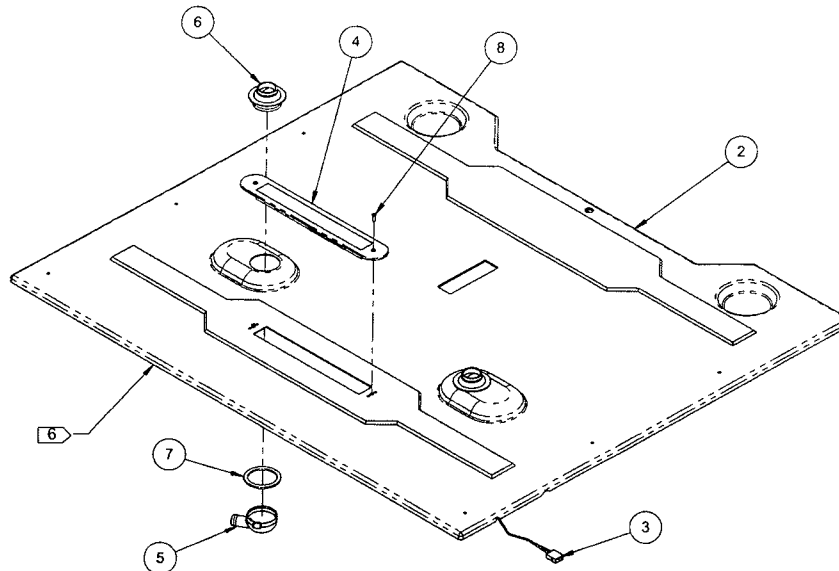
D4634-041 FWD, CENTER CEILING PANEL ASSY
AUXILIARY VIEW

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MFG. APPR.	<i>[Signature]</i>	D4634	SHEET 2 OF 17
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CENTER CEILING PANELS	NTS
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98235

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4634-043	MIDDLE, CENTER CEILING PANEL ASSY
2	1	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4728-053	CABIN LIGHT #2 HARNESS ASSEMBLY
4	1	D4638-1	LED LIGHT
5	2	D4646-1	PLENUM CAP ASSEMBLY
6	2	D4652-1	AIR VALVE
7	2	D4652-3	MOUNTING NUT
8	2	MS24694-S5	SCREW
9	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)







D4634-043 MIDDLE, CENTER CEILING PANEL ASSY

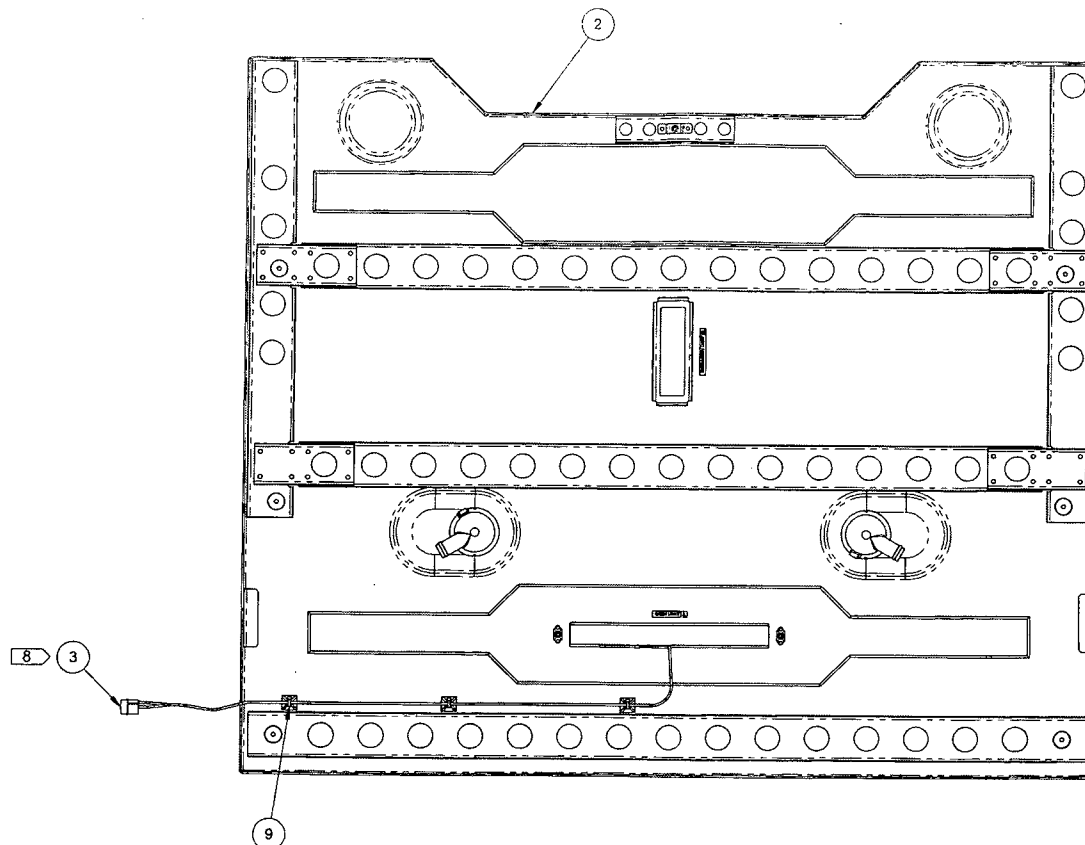
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 9.5 lbs
- 8) INSTALL D4728-053 WIRE HARNESS PER QSI 048

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2013-01-30
JMD

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4634	SHEET 3 OF 17
APPROVED		TITLE	SCALE
DE APPR.		CENTER CEILING PANELS	NTS
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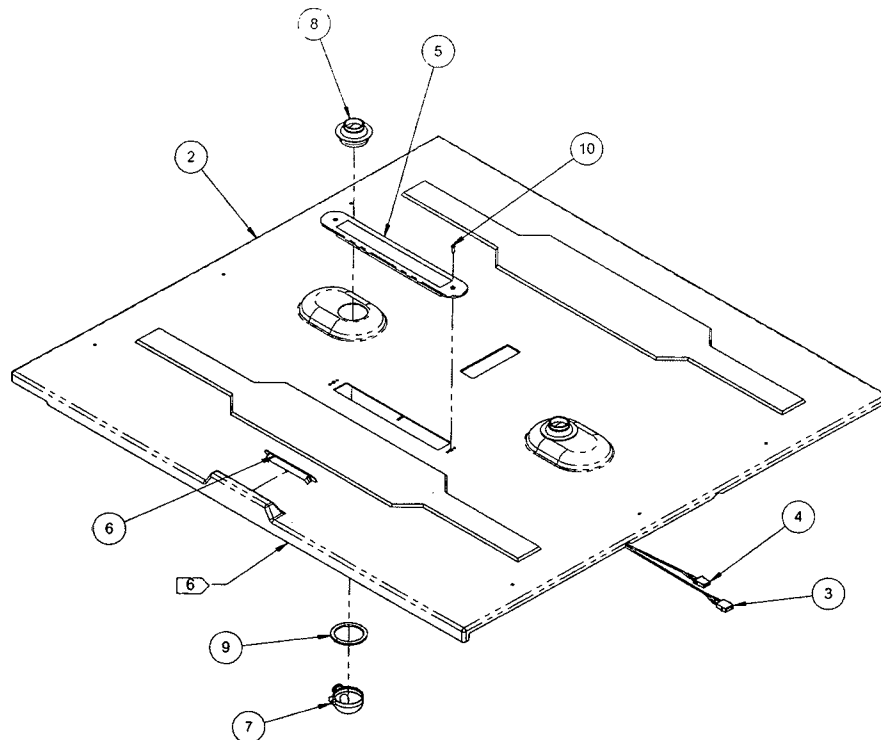


D4634-043 MIDDLE, CENTER CEILING PANEL ASSY
AUXILIARY VIEW

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MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 4 OF 17
APPROVED	<i>[Signature]</i>	SCALE	NTS
DE APPR.	<i>[Signature]</i>	CENTER CEILING PANELS	
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D4634-045 AFT, CENTER CEILING PANEL ASSY

NOTES:

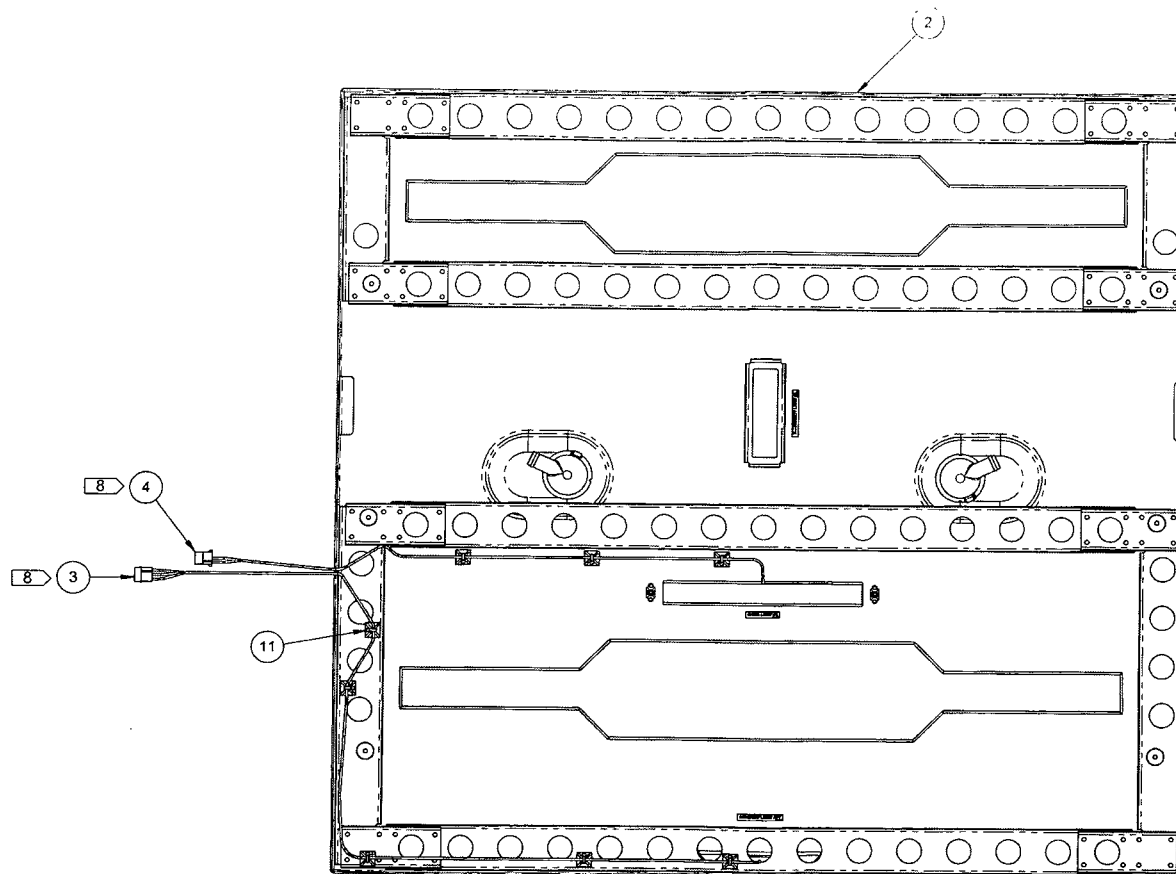
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 10.0 lbs
- 8) INSTALL D4728-049/-055 WIRE HARNESS PER QSI 048

ITEM NO.	QTY. -045	PART NUMBER	DESCRIPTION
1	X	D4634-045	AFT, CENTER CEILING PANEL ASSY
2	1	D4634-145	AFT, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4728-049	ADVISORY LIGHT (AFT) HARNESS ASSEMBLY
4	1	D4728-055	CABIN LIGHT #3 ASSEMBLY
5	1	D4638-1	LED LIGHT
6	1	D4645-1	NO SMOKING & FASTEN BELT LIGHT
7	2	D4646-1	PLENUM CAP ASSEMBLY
8	2	D4652-1	AIR VALVE
9	2	D4652-3	MOUNTING NUT
10	2	MS24694-S5	SCREW
11	8	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

RELEASED
2013-01-30
MP

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4634	SHEET 5 OF 17
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CENTER CEILING PANELS	NTS
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98235



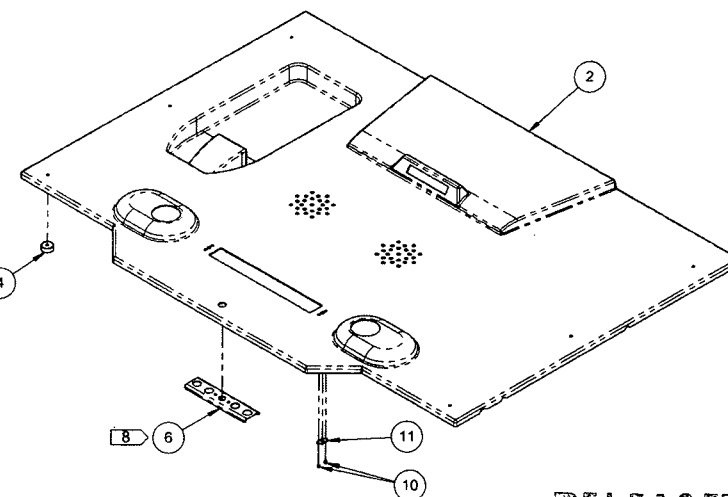
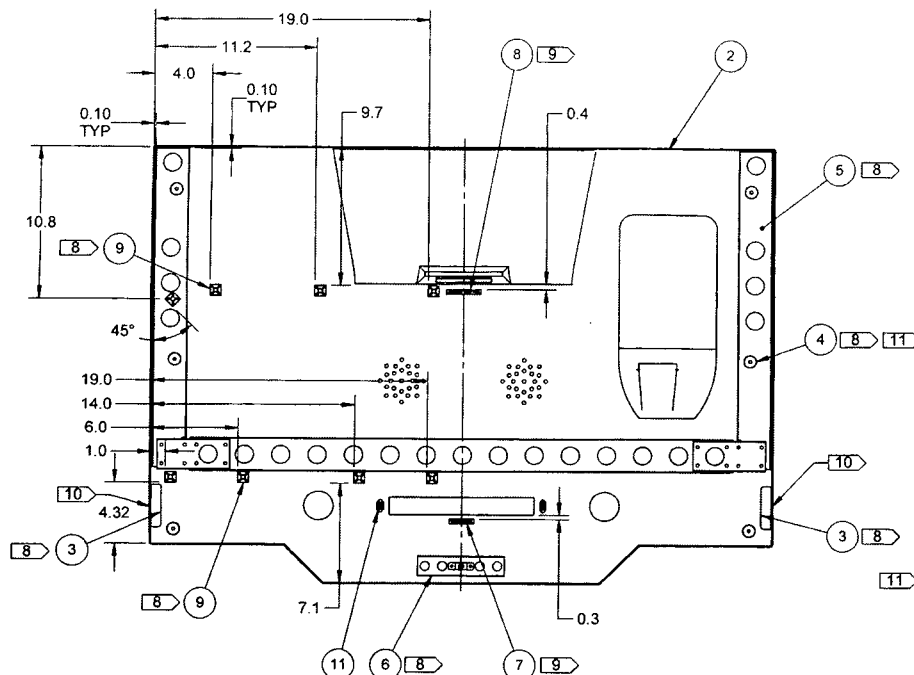
D4634-045 AFT, CENTER CEILING PANEL ASSY
AUXILIARY VIEW

REF 2013-01-30

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4634	SHEET 6 OF 17
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CENTER CEILING PANELS	NTS
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98235

ITEM NO.	QTY. -141	PART NUMBER	DESCRIPTION
1	X	D4634-141	FWD, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-1	FWD, CENTER CEILING PANEL
3	2	D4647-3	ANGLE
4	6	D4664-5	SPACER
5	1	D4694-041	FWD CHANNEL ASSEMBLY
6	1	D4712-041	BRACKET ASSEMBLY
7	1	D4732-15	LABEL
8	1	D4732-19	LABEL
9	8	MPNY-750S-9-C	MOUNTING PAD
10	4	MS20426AD3-3	RIVET
11	2	MS21059L3	ANCHOR NUT



D4634-141 FWD, CENTER CEILING REPLACEMENT PANEL ASSY

NOTES:

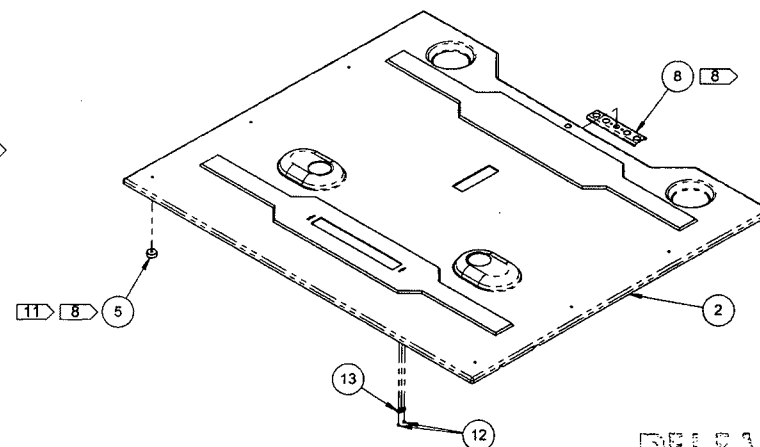
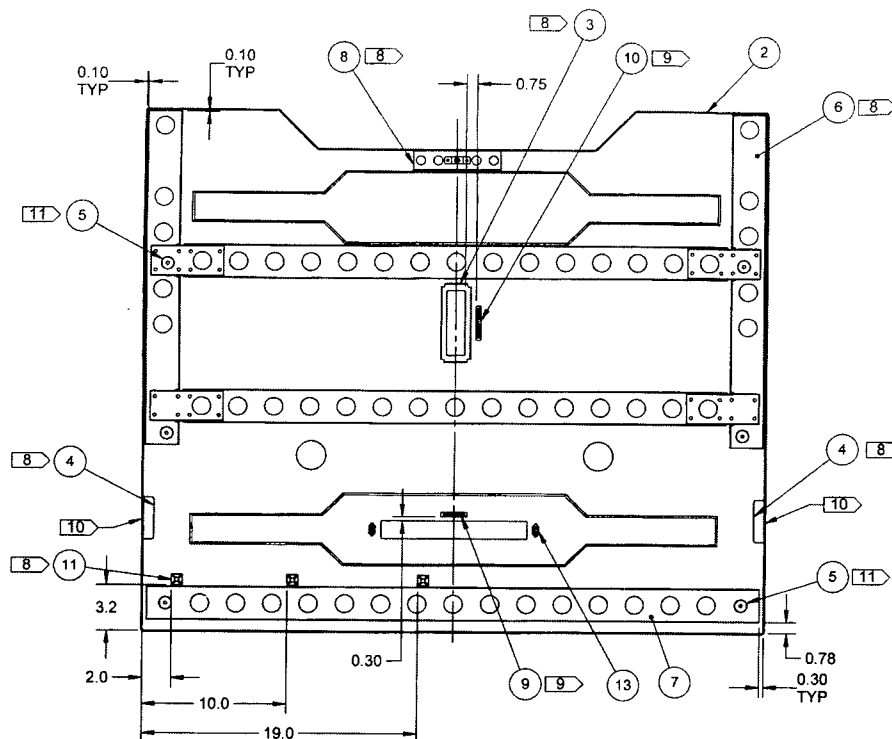
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.3 lbs
- 8) APPLY A LAYER OF DEVCON PLASTIC WELDER II (0.02 TO 0.04 THICK) TO BOND D4647-3, D4664-5, D4694-041, D4712-041 & MPNY-750S-9C. WAIT FOR 24 HOURS TO CURE. LOCATE D4664-5 IN LINE WITH Ø0.204 HOLES
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) LOCATE D4647-3 ANGLE USING GROOVE TO ALIGN WITH D4634-1 FWD CENTER PANEL
- 11) TRANSFER Ø0.204 (#6 DRILL) FROM D4634-1 TO D4694-041 PRIOR TO BONDING D4664-5

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2013-01-30

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4634	SHEET 7 OF 17
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CENTER CEILING PANELS	NTS
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98235

ITEM NO.	QTY -143	PART NUMBER	DESCRIPTION
1	X	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-3	MIDDLE, CENTER CEILING PANEL
3	1	D4647-1	DOUBLER
4	2	D4647-3	ANGLE
5	6	D4664-5	SPACER
6	1	D4694-043	MIDDLE CHANNEL ASSEMBLY
7	1	D4694-7	MIDDLE CHANNEL
8	1	D4712-041	BRACKET ASSEMBLY
9	1	D4732-21	LABEL
10	1	D4732-25	LABEL
11	3	MPNY-750S-9-C	MOUNTING PAD
12	4	MS20426AD3-3	RIVET
13	2	MS21059L3	ANCHOR NUT



D4634-143 MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.5 lbs
- 8) APPLY A LAYER OF DEVCON PLASTIC WELDER II (0.02 TO 0.04 THICK) TO BOND D4647-1, D4647-3, D4664-5, D4694-043/-7, D4712-041 & MPNY-750S-9C WAIT FOR 24 HOURS TO CURE. LOCATE D4664-5 IN LINE WITH Ø0.204 HOLES. LOCATE D4647-1 IN LINE WITH RECTANGULAR OPENING
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) LOCATE D4647-3 ANGLE USING GROOVE TO ALIGN WITH D4634-3 MIDDLE CENTER PANEL
- 11) TRANSFER Ø0.204 (#6 DRILL) FROM D4634-3 TO D4694-043/-7 PRIOR TO BONDING D4664-5

RELEASED
2013-01-30

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D4634	REV. B
MFG. APPR.		SHEET 8 OF 17	
APPROVED		TITLE	SCALE
DE APPR.		CENTER CEILING PANELS	NTS
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Technical drawing of a rectangular frame assembly, likely a component of a vehicle interior. The drawing shows a top-down view of the frame, which consists of a central rectangular opening surrounded by a border. The border is composed of several horizontal and vertical sections, each featuring a series of circular holes. The central opening has a complex, elongated shape with a central rectangular cutout. Dimensions are provided in inches, with some values in parentheses indicating typical or alternative measurements. Callouts (1) through (13) identify specific components or features. The drawing is oriented with the longer side of the frame (19.6 inches) running horizontally.

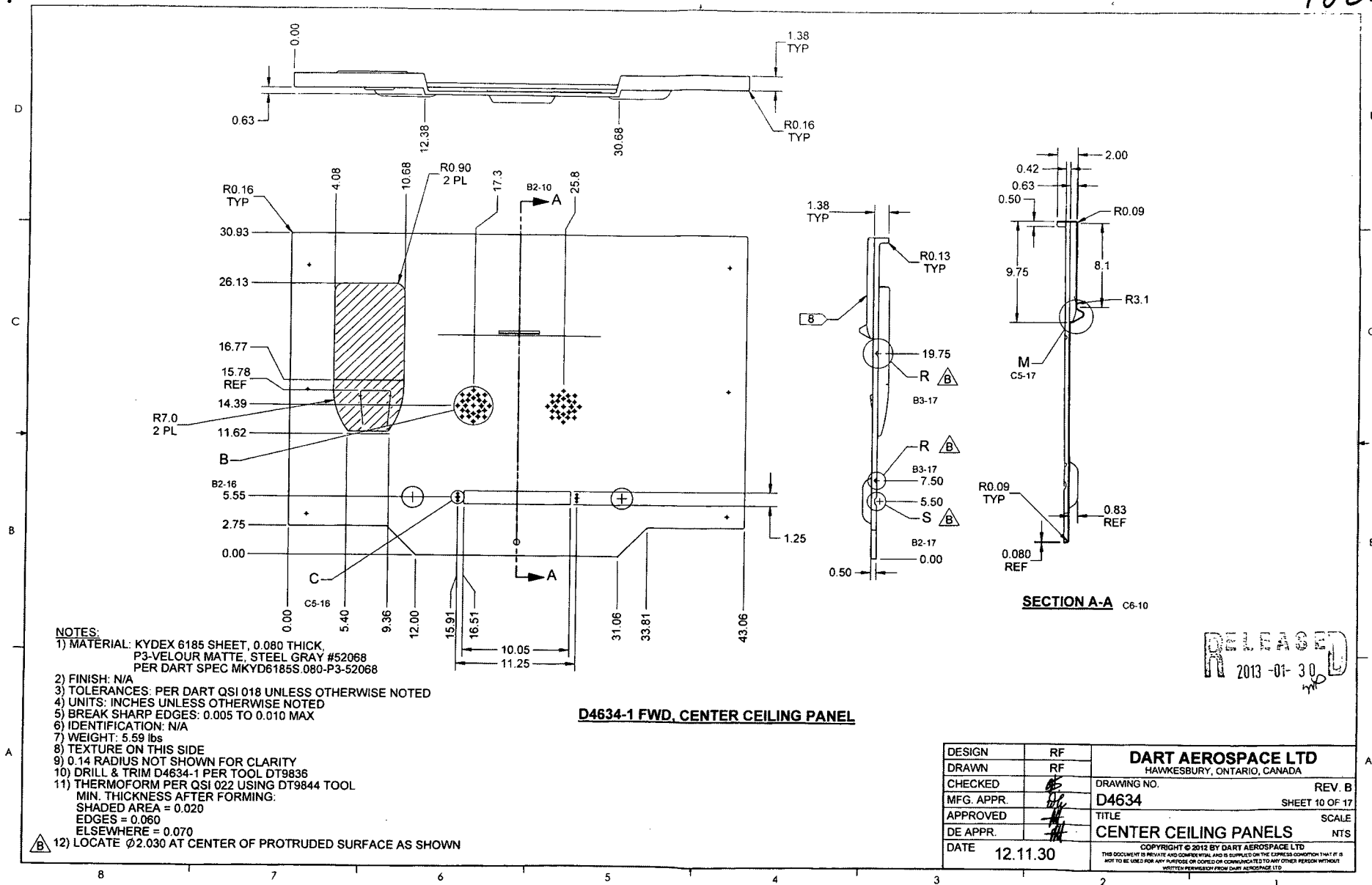
Dimensions (inches):

- Overall width: 19.6
- Overall height: 15.8
- Top horizontal section width: 12.3
- Bottom horizontal section width: 12.3
- Left vertical section height: 12.0
- Right vertical section height: 9.0
- Central opening width: 12.5
- Central opening height: 6.0
- Top horizontal section height: 0.10 (TYP)
- Bottom horizontal section height: 0.10 (TYP)
- Left vertical section width: 1.4
- Right vertical section width: 1.4

Callouts (1) through (13) identify specific components or features:

- (1) Top horizontal section
- (2) Right vertical section
- (3) Central opening
- (4) Bottom horizontal section
- (5) Left vertical section
- (6) Top horizontal section (inner)
- (7) Right vertical section (inner)
- (8) Central opening (inner)
- (9) Bottom horizontal section (inner)
- (10) Left vertical section (inner)
- (11) Top horizontal section (outer)
- (12) Right vertical section (outer)
- (13) Central opening (outer)

98235



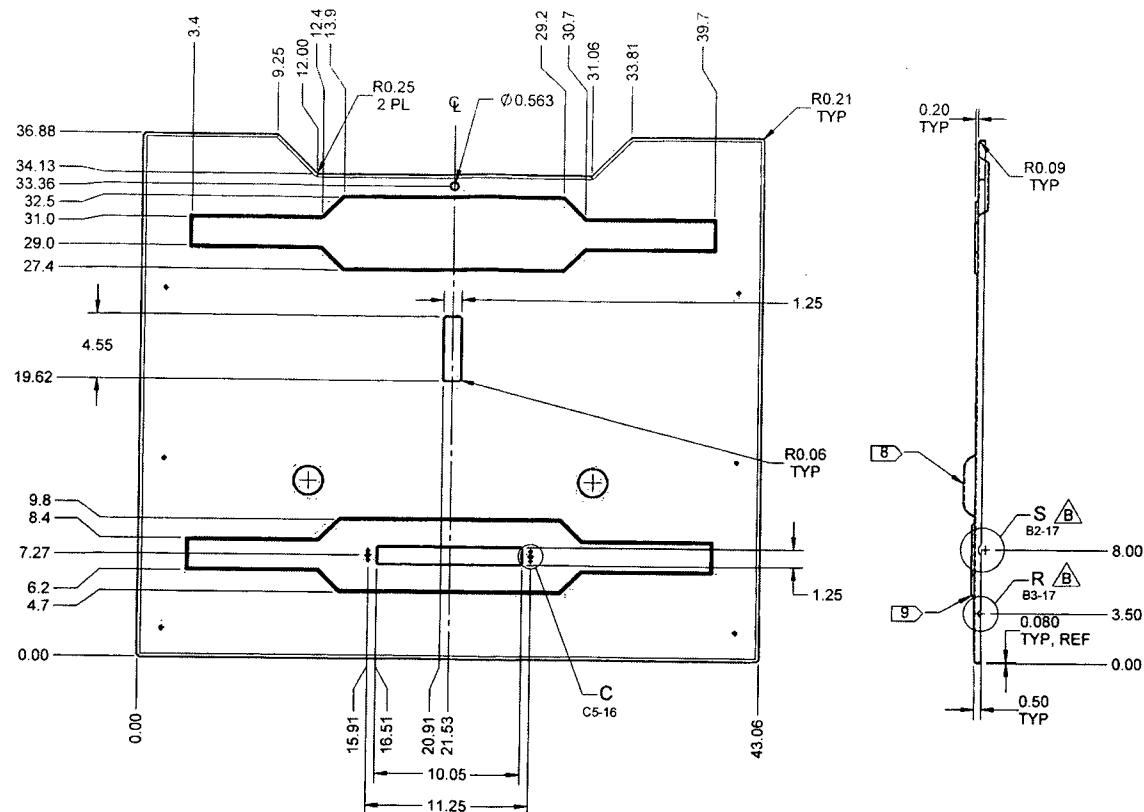
A B C D



DESIGN	RF	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA DRAWING NO. D4634 TITLE CENTER CEILING PANELS COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO PART HEREOF IS TO BE REPRODUCED OR USED FOR ANY PURPOSE OR FOR THE COORDINATION OF ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. 1
DRAWN	RF		SHEET 11 OF 11
CHECKED	RF		SCALE
MFG. APPR.	RF		NTS
APPROVED	RF		
DE APPR.	RF		
DATE	12.11.30		

RELEASE
2013-01-30

98235



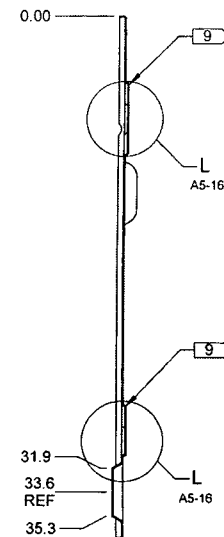
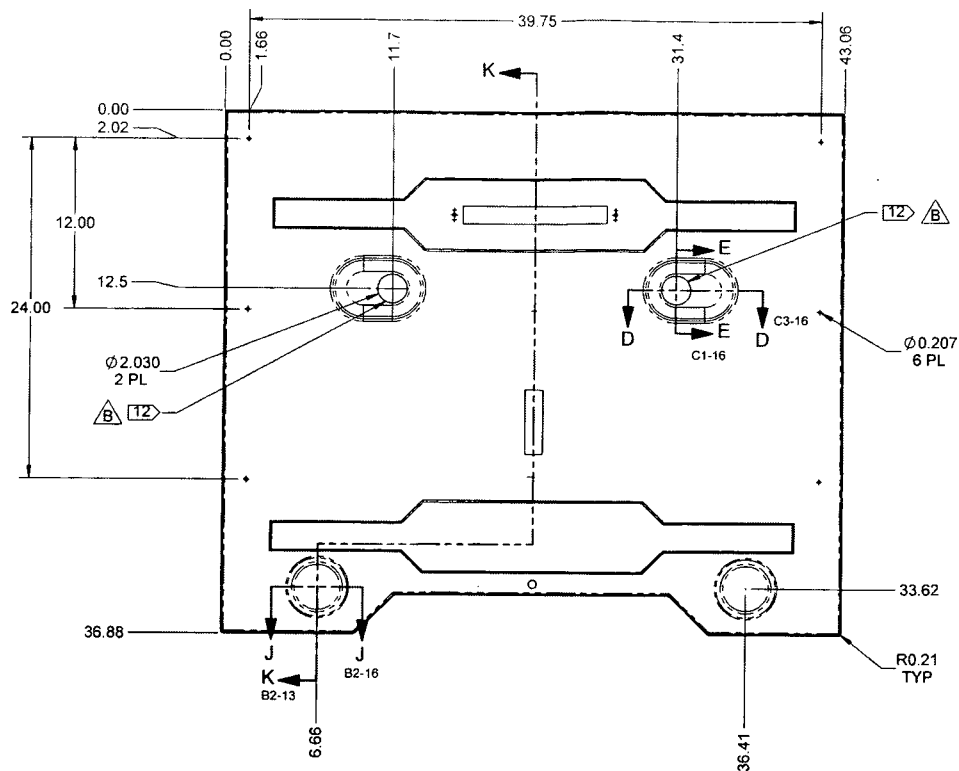
- NOTES:**
- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,
P3-VELOUR MATTE, STEEL GRAY #52068
PER DART SPEC MKYD6185S.080-P3-52068
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 6.31 lbs
 - 8) TEXTURE ON THIS SIDE
 - 9) 0.14 RADIUS NOT SHOWN FOR CLARITY
 - 10) DRILL & TRIM D4634-3 PER TOOL DT9837
 - 11) THERMOFORM PER QSI 022 USING DT9845 TOOL
MIN. THICKNESS AFTER FORMING:
EDGES = 0.060
ELSEWHERE = 0.070
 - 12) LOCATE Ø2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-3 MIDDLE, CENTER CEILING PANEL

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98235



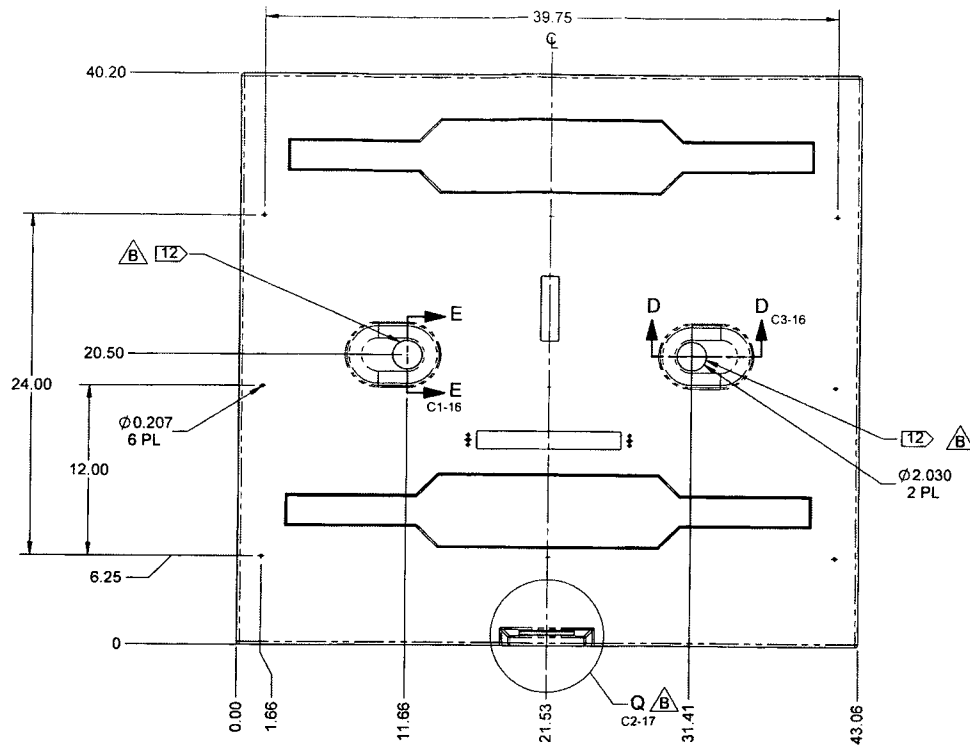
SECTION K-K 86-13

D4634-3 MIDDLE CENTER CEILING PANEL
AUXILIARY VIEW

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D4634-5 AFT. CENTER CEILING PANEL
AUXILIARY VIEW

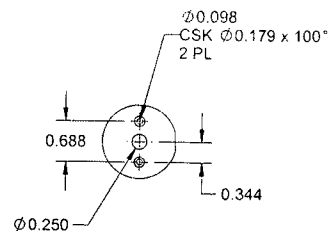
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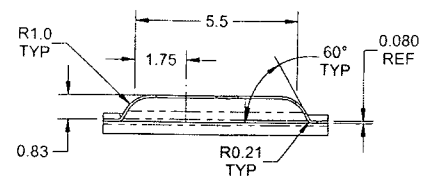
Technical drawing of a vertical component with the following dimensions and labels:

- Top width: 0.080
- Reference: REF
- Top radius: R0.13 TYP
- Upper section width: 1.5
- Upper section height: 9.4
- Lower section width: 1.68
- Lower section height: 0.5
- Bottom radius: R10.4
- Bottom radius: R20.0
- Overall height: 10.35
- Lower section height: 3.9

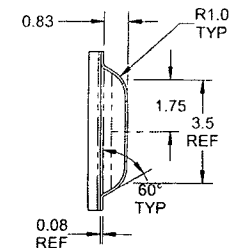
SECTION G-G C5-11
SCALE 4X



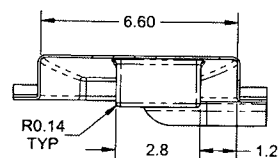
DETAIL C B7-10
SCALE 4X B4-12
B4-14



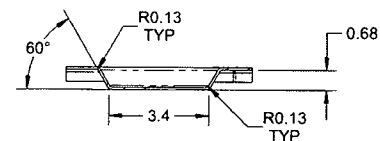
SECTION D-D B6-11
SCALE 2X C4-13
C4-15



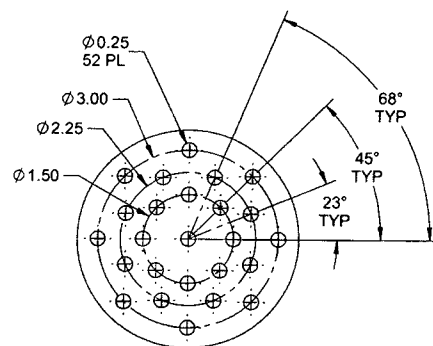
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SCALE 4X C4-13
C5-15



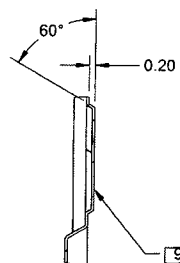
SECTION H-H C5-11
SCALE 2X



SECTION J-J B6-13
SCALE 2X



DETAIL B B7-10
SCALE 4X
2 PL

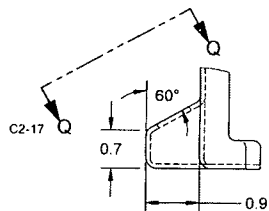


DETAIL L
SCALE 4X
TYP

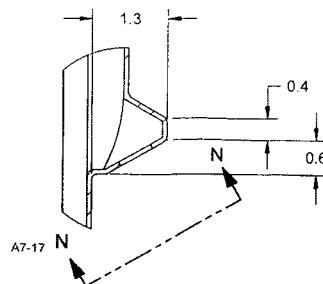
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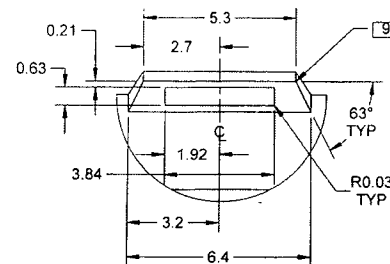
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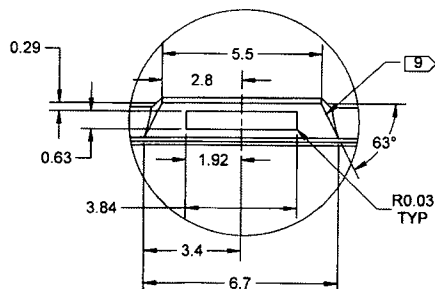
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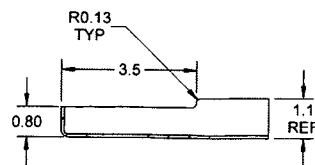
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SCALE 2X



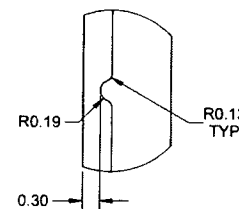
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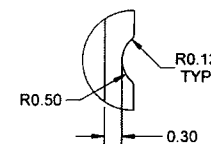
DETAIL N C5-17
SCALE 0.5X B4-15



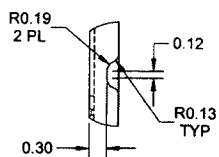
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10
SCALE 4X C3-10
B2-12



DETAIL S B3-10
SCALE 4X C2-12



DETAIL T C2-14
SCALE 4X

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